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Hawkesbury, ON  
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Canada

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**D212-664-101**  
**Job Sheet 194988**



**Part No:** D212-664-101

**Job Qty:** 1 pcs

**Part Name:** Fwd Crosstube - High



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 5/13/19

**Job Tracking No:**

**Due Date:** 5/27/19

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:**

**Note:** D212-664-141 REV E/ IIN-D212-664 REV.J IPP Rev:E 04.02.16 Reformat KJ/DS IPP Rev:F 06-03-29 Remove  
Comments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 11.04.26 Inspection strip ecn 11-  
549 EC verf by:DD IPP REV:I 14.05.27 AS PER ECN 14-570 DD VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op<br>No | Operation              | Qty | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |              | Sign-off |
|----------|------------------------|-----|------------|-------------|--------------|------------|-----------------------|--------------|----------|
|          |                        |     |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead<br>Time |          |
| 110      | Packaging 1 - Pick Kit | 1   |            | 5/27/19     | 0.00         | 0.00       | Packaging 1 - 1       |              |          |
|          |                        | pcs |            |             |              |            | Packaging 1 - 2       |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 3       |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 4       |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 5       |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 6       |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 7       |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 8       |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 9       |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 10      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 11      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 12      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 13      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 14      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 15      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 16      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 17      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 18      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 19      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 20      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 21      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 22      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 23      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 24      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 25      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 26      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 27      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 28      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 29      |              |          |
|          |                        |     |            |             |              |            | Packaging 1 - 30      |              |          |

Plex 5/13/19 9:03 AM Dart.lajeunesse.marie

D212-664-101/194988/S181081

NCR: 19-7235

|                                 |          |         |      |      |                         |                               |
|---------------------------------|----------|---------|------|------|-------------------------|-------------------------------|
|                                 |          |         |      |      | Packaging 1 - 31        |                               |
|                                 |          |         |      |      | Packaging 1 - 32        |                               |
|                                 |          |         |      |      | Packaging 1 - 33        |                               |
|                                 |          |         |      |      | Packaging 1 - 34        |                               |
|                                 |          |         |      |      | Packaging 1 - 35        |                               |
|                                 |          |         |      |      | Packaging 1 - 36        |                               |
| 120 Crosstubes - Bend - 2 - B4B | 1<br>pcs | 5/27/19 | 3.11 | 1.00 | Crosstubes - Bend - B4B | GP 19-05-16                   |
| 130 QC 15                       | 1<br>pcs | 5/27/19 | 0.00 | 0.00 | QC 15 - 12              |                               |
|                                 |          |         |      |      | QC 15 - 3               |                               |
|                                 |          |         |      |      | QC 15 - 47              |                               |
|                                 |          |         |      |      | QC 15 - 49              |                               |
|                                 |          |         |      |      | QC 15 - 58              |                               |
|                                 |          |         |      |      | QC 15 - 9               |                               |
| 140 Crosstubes - 2 - B4B        | 1<br>pcs | 5/27/19 | 0.00 | 1.00 | QC 15 - 68              | DAS<br>MAY 23 2019 68<br>9-89 |
|                                 |          |         |      |      | Crosstubes - 1 - B4B    |                               |
|                                 |          |         |      |      | Crosstubes - 2 - B4B    | GP 19-05-16                   |
|                                 |          |         |      |      | Crosstubes - 3 - B4B    |                               |
| 150 Crosstubes - 3 - B4B        | 1<br>pcs | 5/27/19 | 0.00 | 0.50 | Crosstubes - 4 - B4B    |                               |
|                                 |          |         |      |      | Crosstubes - 1 - B4B    |                               |
|                                 |          |         |      |      | Crosstubes - 2 - B4B    | GP 19-05-28                   |
|                                 |          |         |      |      | Crosstubes - 3 - B4B    |                               |
| 160 QC 7                        | 1<br>pcs | 5/27/19 | 0.00 | 0.00 | Crosstubes - 4 - B4B    |                               |
|                                 |          |         |      |      | QC 7 - 10               |                               |
|                                 |          |         |      |      | QC 7 - 13               |                               |
|                                 |          |         |      |      | QC 7 - 14               |                               |
|                                 |          |         |      |      | QC 7 - 15               |                               |
|                                 |          |         |      |      | QC 7 - 17               |                               |
|                                 |          |         |      |      | QC 7 - 18               |                               |
|                                 |          |         |      |      | QC 7 - 19               |                               |
|                                 |          |         |      |      | QC 7 - 2                |                               |
|                                 |          |         |      |      | QC 7 - 28               |                               |
|                                 |          |         |      |      | QC 7 - 3                |                               |
|                                 |          |         |      |      | QC 7 - 30               |                               |
|                                 |          |         |      |      | QC 7 - 34               |                               |
|                                 |          |         |      |      | QC 7 - 36               |                               |
|                                 |          |         |      |      | QC 7 - 37               |                               |
|                                 |          |         |      |      | QC 7 - 41               |                               |
|                                 |          |         |      |      | QC 7 - 47               |                               |
|                                 |          |         |      |      | QC 7 - 48               |                               |
|                                 |          |         |      |      | QC 7 - 51               |                               |
|                                 |          |         |      |      | QC 7 - 58               |                               |
|                                 |          |         |      |      | QC 7 - 59               |                               |
|                                 |          |         |      |      | QC 7 - 60               |                               |
|                                 |          |         |      |      | QC 7 - 9                |                               |
|                                 |          |         |      |      | QC 7 - 68               | DAS<br>MAY 28 2019 68<br>9-89 |
|                                 |          |         |      |      | QC 7 - 50               |                               |
|                                 |          |         |      |      | QC 7 - 67               |                               |
|                                 |          |         |      |      | QC 7 - 40               |                               |
|                                 |          |         |      |      | QC 7 - 24               |                               |
|                                 |          |         |      |      | QC 7 - 43               |                               |
| 165 QC 5                        | 1<br>pcs | 5/27/19 | 0.00 | 0.00 | QC 5 - 10               |                               |
|                                 |          |         |      |      | QC 5 - 12               |                               |
|                                 |          |         |      |      | QC 5 - 17               |                               |
|                                 |          |         |      |      | QC 5 - 18               |                               |
|                                 |          |         |      |      | QC 5 - 19               |                               |
|                                 |          |         |      |      | QC 5 - 22               |                               |
|                                 |          |         |      |      | QC 5 - 24               |                               |
|                                 |          |         |      |      | QC 5 - 3                |                               |

|     |                                |       |         |           |                        |
|-----|--------------------------------|-------|---------|-----------|------------------------|
|     |                                |       |         | QC 5 - 43 |                        |
|     |                                |       |         | QC 5 - 49 |                        |
|     |                                |       |         | QC 5 - 51 |                        |
|     |                                |       |         | QC 5 - 58 |                        |
|     |                                |       |         | QC 5 - 68 | MAY 28 2019 68         |
|     |                                |       |         | QC 5 - 9  | 9-89                   |
|     |                                |       |         | QC 5 - 50 |                        |
|     |                                |       |         | QC 5 - 30 |                        |
|     |                                |       |         | QC 5 - 40 |                        |
| 170 | Outsource - 2 - NDT per QSI038 | 1 pcs | 5/27/19 | SKY002-VC | 2019-05-30             |
| 180 | Packaging 2-1 - Receive - B4B  | 1 pcs | 5/27/19 | 0.00 0.00 | Packaging 2 - 1 - B4B  |
|     |                                |       |         |           | Packaging 2 - 2 - B4B  |
|     |                                |       |         |           | Packaging 2 - 3 - B4B  |
|     |                                |       |         |           | Packaging 2 - 5 - B4B  |
|     |                                |       |         |           | Packaging 2 - 4 - B4B  |
|     |                                |       |         |           | Packaging 2 - 6 - B4B  |
|     |                                |       |         |           | Packaging 2 - 7 - B4B  |
|     |                                |       |         |           | Packaging 2 - 8 - B4B  |
|     |                                |       |         |           | Packaging 2 - 9 - B4B  |
|     |                                |       |         |           | Packaging 2 - 10 - B4B |
|     |                                |       |         |           | Packaging 2 - 11 - B4B |
|     |                                |       |         |           | Packaging 2 - 12 - B4B |
|     |                                |       |         |           | Packaging 2 - 13 - B4B |
|     |                                |       |         |           | Packaging 2 - 14 - B4B |
|     |                                |       |         |           | Packaging 2 - 15 - B4B |
|     |                                |       |         |           | Packaging 2 - 16 - B4B |
|     |                                |       |         |           | Packaging 2 - 17 - B4B |
|     |                                |       |         |           | Packaging 2 - 18 - B4B |
|     |                                |       |         |           | Packaging 2 - 19 - B4B |
|     |                                |       |         |           | Packaging 2 - 20 - B4B |
|     |                                |       |         |           | Packaging 2 - 21 - B4B |
|     |                                |       |         |           | Packaging 2 - 22 - B4B |
|     |                                |       |         |           | Packaging 2 - 23 - B4B |
|     |                                |       |         |           | Packaging 2 - 24 - B4B |
|     |                                |       |         |           | Packaging 2 - 25 - B4B |
|     |                                |       |         |           | Packaging 2 - 26 - B4B |
|     |                                |       |         |           | Packaging 2 - 27 - B4B |
|     |                                |       |         |           | Packaging 2 - 28 - B4B |
|     |                                |       |         |           | Packaging 2 - 29 - B4B |
|     |                                |       |         |           | Packaging 2 - 30 - B4B |
|     |                                |       |         |           | Packaging 2 - 31 - B4B |
|     |                                |       |         |           | Packaging 2 - 32 - B4B |
|     |                                |       |         |           | Packaging 2 - 33 - B4B |
|     |                                |       |         |           | Packaging 2 - 34 - B4B |
|     |                                |       |         |           | Packaging 2 - 35 - B4B |
|     |                                |       |         |           | Packaging 2 - 36 - B4B |
| 190 | QC 5                           | 1 pcs | 5/27/19 | 0.00 0.00 | QC 5 - 10              |
|     |                                |       |         |           | QC 5 - 12              |
|     |                                |       |         |           | QC 5 - 17              |
|     |                                |       |         |           | QC 5 - 18              |
|     |                                |       |         |           | QC 5 - 19              |
|     |                                |       |         |           | QC 5 - 22              |
|     |                                |       |         |           | QC 5 - 24              |
|     |                                |       |         |           | QC 5 - 3               |
|     |                                |       |         |           | QC 5 - 43              |
|     |                                |       |         |           | QC 5 - 49              |
|     |                                |       |         |           | QC 5 - 51              |
|     |                                |       |         |           | QC 5 - 58              |

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|                                    |          |         |      |      |                        |             |            |
|------------------------------------|----------|---------|------|------|------------------------|-------------|------------|
|                                    |          |         |      |      | QC 5 - 68              | JUN 03 2019 | 68<br>9-89 |
|                                    |          |         |      |      | QC 5 - 9               |             |            |
|                                    |          |         |      |      | QC 5 - 50              |             |            |
|                                    |          |         |      |      | QC 5 - 30              |             |            |
|                                    |          |         |      |      | QC 5 - 40              |             |            |
| 200 Spray Paint - 2 - B4B          | 1<br>pcs | 5/27/19 | 0.00 | 0.25 | Spray Paint - 1 - B4B  |             | AB 19-6-1  |
|                                    |          |         |      |      | Spray Paint - 2 - B4B  |             |            |
|                                    |          |         |      |      | Spray Paint - 3 - B4B  |             |            |
|                                    |          |         |      |      | Spray Paint - 4 - B4B  |             |            |
| 210 QC 14                          | 1<br>pcs | 5/27/19 | 0.00 | 0.00 | QC 14 - 15             | JUN 05 2019 | 68<br>9-89 |
|                                    |          |         |      |      | QC 14 - 2              |             |            |
|                                    |          |         |      |      | QC 14 - 34             |             |            |
|                                    |          |         |      |      | QC 14 - 41             |             |            |
|                                    |          |         |      |      | QC 14 - 51             |             |            |
|                                    |          |         |      |      | QC 14 - 58             |             |            |
|                                    |          |         |      |      | QC 14 - 59             |             |            |
|                                    |          |         |      |      | QC 14 - 9              |             |            |
|                                    |          |         |      |      | QC 14 - 68             |             |            |
|                                    |          |         |      |      | QC 14 - 40             |             |            |
|                                    |          |         |      |      | QC 14 - 19             |             |            |
|                                    |          |         |      |      | QC 14 - 43             |             |            |
| 220 Crosstubes - 4 - B4B           | 1<br>pcs | 5/27/19 | 0.00 | 1.69 | Crosstubes - 1 - B4B   |             | AB 19-6-2  |
|                                    |          |         |      |      | Crosstubes - 2 - B4B   |             |            |
|                                    |          |         |      |      | Crosstubes - 3 - B4B   |             |            |
|                                    |          |         |      |      | Crosstubes - 4 - B4B   |             |            |
| 230 QC 5                           | 1<br>pcs | 5/27/19 | 0.00 | 0.00 | QC 5 - 10              | JUN 05 2019 | 68<br>9-89 |
|                                    |          |         |      |      | QC 5 - 12              |             |            |
|                                    |          |         |      |      | QC 5 - 17              |             |            |
|                                    |          |         |      |      | QC 5 - 18              |             |            |
|                                    |          |         |      |      | QC 5 - 19              |             |            |
|                                    |          |         |      |      | QC 5 - 22              |             |            |
|                                    |          |         |      |      | QC 5 - 24              |             |            |
|                                    |          |         |      |      | QC 5 - 3               |             |            |
|                                    |          |         |      |      | QC 5 - 43              |             |            |
|                                    |          |         |      |      | QC 5 - 49              |             |            |
|                                    |          |         |      |      | QC 5 - 51              |             |            |
|                                    |          |         |      |      | QC 5 - 58              |             |            |
|                                    |          |         |      |      | QC 5 - 68              |             |            |
|                                    |          |         |      |      | QC 5 - 9               |             |            |
|                                    |          |         |      |      | QC 5 - 50              |             |            |
|                                    |          |         |      |      | QC 5 - 30              |             |            |
| 240 Packaging 1-1 - Pick Kit - B4B | 1<br>pcs | 5/27/19 | 0.00 | 0.00 | Packaging 1 - 1 - B4B  |             |            |
|                                    |          |         |      |      | Packaging 1 - 2 - B4B  |             |            |
|                                    |          |         |      |      | Packaging 1 - 3 - B4B  |             |            |
|                                    |          |         |      |      | Packaging 1 - 4 - B4B  |             |            |
|                                    |          |         |      |      | Packaging 1 - 5 - B4B  |             |            |
|                                    |          |         |      |      | Packaging 1 - 6 - B4B  |             |            |
|                                    |          |         |      |      | Packaging 1 - 7 - B4B  |             |            |
|                                    |          |         |      |      | Packaging 1 - 8 - B4B  |             |            |
|                                    |          |         |      |      | Packaging 1 - 9 - B4B  |             |            |
|                                    |          |         |      |      | Packaging 1 - 10 - B4B |             |            |
|                                    |          |         |      |      | Packaging 1 - 11 - B4B |             |            |
|                                    |          |         |      |      | Packaging 1 - 12 - B4B |             |            |
|                                    |          |         |      |      | Packaging 1 - 13 - B4B |             |            |
|                                    |          |         |      |      | Packaging 1 - 14 - B4B |             |            |
|                                    |          |         |      |      | Packaging 1 - 15 - B4B |             |            |
|                                    |          |         |      |      | Packaging 1 - 16 - B4B |             |            |

|                                 |          |         |      |      |                        |         |
|---------------------------------|----------|---------|------|------|------------------------|---------|
|                                 |          |         |      |      | Packaging 1 - 17 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 18 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 19 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 20 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 21 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 22 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 23 - B4B | PC.     |
|                                 |          |         |      |      | Packaging 1 - 24 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 25 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 26 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 27 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 28 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 29 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 30 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 31 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 32 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 33 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 34 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 35 - B4B |         |
|                                 |          |         |      |      | Packaging 1 - 36 - B4B |         |
| 250 QC 4                        | 1<br>pcs | 5/27/19 | 0.00 | 0.00 | QC 4 - 28              |         |
|                                 |          |         |      |      | QC 4 - 58              | SMB     |
|                                 |          |         |      |      | QC 4 - 69              | 19/6/17 |
|                                 |          |         |      |      | QC 4 - 9               |         |
|                                 |          |         |      |      | QC 4 - 46              |         |
|                                 |          |         |      |      | QC 4 - 68              |         |
| 260 Packaging 3-1 - Stock - B4B | 1<br>pcs | 5/27/19 | 0.00 | 0.00 | QC 4 - 72              |         |
|                                 |          |         |      |      | Packaging 3 - 1 - B4B  |         |
|                                 |          |         |      |      | Packaging 3 - 2 - B4B  |         |
|                                 |          |         |      |      | Packaging 3 - 3 - B4B  |         |
|                                 |          |         |      |      | Packaging 3 - 4 - B4B  |         |
|                                 |          |         |      |      | Packaging 3 - 5 - B4B  |         |
|                                 |          |         |      |      | Packaging 3 - 6 - B4B  |         |
|                                 |          |         |      |      | Packaging 3 - 7 - B4B  | SMB     |
|                                 |          |         |      |      | Packaging 3 - 8 - B4B  | 19/6/17 |
|                                 |          |         |      |      | Packaging 3 - 9 - B4B  |         |
|                                 |          |         |      |      | Packaging 3 - 10 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 11 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 12 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 13 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 14 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 15 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 16 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 17 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 18 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 19 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 20 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 21 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 22 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 23 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 24 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 25 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 26 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 27 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 28 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 29 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 30 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 31 - B4B |         |
|                                 |          |         |      |      | Packaging 3 - 32 - B4B |         |

|                  |     |         |           |                        |                |
|------------------|-----|---------|-----------|------------------------|----------------|
|                  |     |         |           | Packaging 3 - 33 - B4B | 010091         |
|                  |     |         |           | Packaging 3 - 34 - B4B |                |
|                  |     |         |           | Packaging 3 - 35 - B4B |                |
|                  |     |         |           | Packaging 3 - 36 - B4B |                |
| 265 DC - 1 - B4B | 1   | 5/27/19 | 0.00 0.00 | DC - 1 - B4B           | 21 JUN 07 2019 |
|                  | pcs |         |           | DC - 2 - B4B           | 21             |
| 270 QC 21 - FG   | 1   | 5/27/19 | 0.00 0.00 | QC 21 - FG - 21        | 21 JUN 07 2019 |
|                  | pcs |         |           | QC 21 - FG - 70        | 21             |
|                  |     |         |           | QC 21 - FG - 53        | 21             |

Part Op 120 - Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101

Descriptions: 130 - (QC15- Crosstube Dimensional Check)

140 - "1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10 2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141 4-\*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\* Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141"

150 - HandFinish5 (Crosstubes Chemical Conversion) \*\*\*IMMEDIATELY AFTER GRINDING\*\*\*

160 - (QC7-Inspect Chemical Conversion Coat)

165 - QC5- Inspect part completeness to step on W/O)

170 - \*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\* Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - (Receive & Inspect for Damage & Mat'l Certs) Ensure copy of NDT results attached to work order.

190 - (QC5- Inspect part completeness to step on W/O) \*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\* Inspect for damage & ensure results are as per Dwg D212-664-141

200 - (Spray Paint / NDT Room) \*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\* 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: 5154197 2- After painting remove masking and apply matte clear coat per QSI005 4.2 3- MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2 Paint 5184740

210 - (QC14- Inspect Spray Paint) Then, Wrap in plastic bag to protect from scratches

220 - \*\*\*\*\*LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MEASURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. \*\*\*\*\* 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-141 and QSI 015 A/R Proseal 890 Batch: 5146134 EXP: 10/19 PROSEAL CURE TIME 72 HOURS: Start: 19-6-2 Finish: 19-6-5 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-141. \*\*\*Torque all clamps to 80-100 IN-LBS.\*\*\*

230 - (QC5- Inspect part completeness to step on W/O) \*\*\*RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.\*\*\*

240 - (Pick Kit)

250 - QC4- 100% Inspect kits for completeness) \*\*\*VERIFY BY \_\_\_\_\_ BATCH # TO MATCH W/O

260 - (Identify as per dwg & Stock Location: \_\_\_\_\_) Identify and pack for shipping as per PPP D212-664-101 Location : FG094

265 - Photocopy bluefile and create labels as per PPP D212-664-101 CHG006

270 - (QC21- Final Inspection - Work Order Release)

## Job BOM

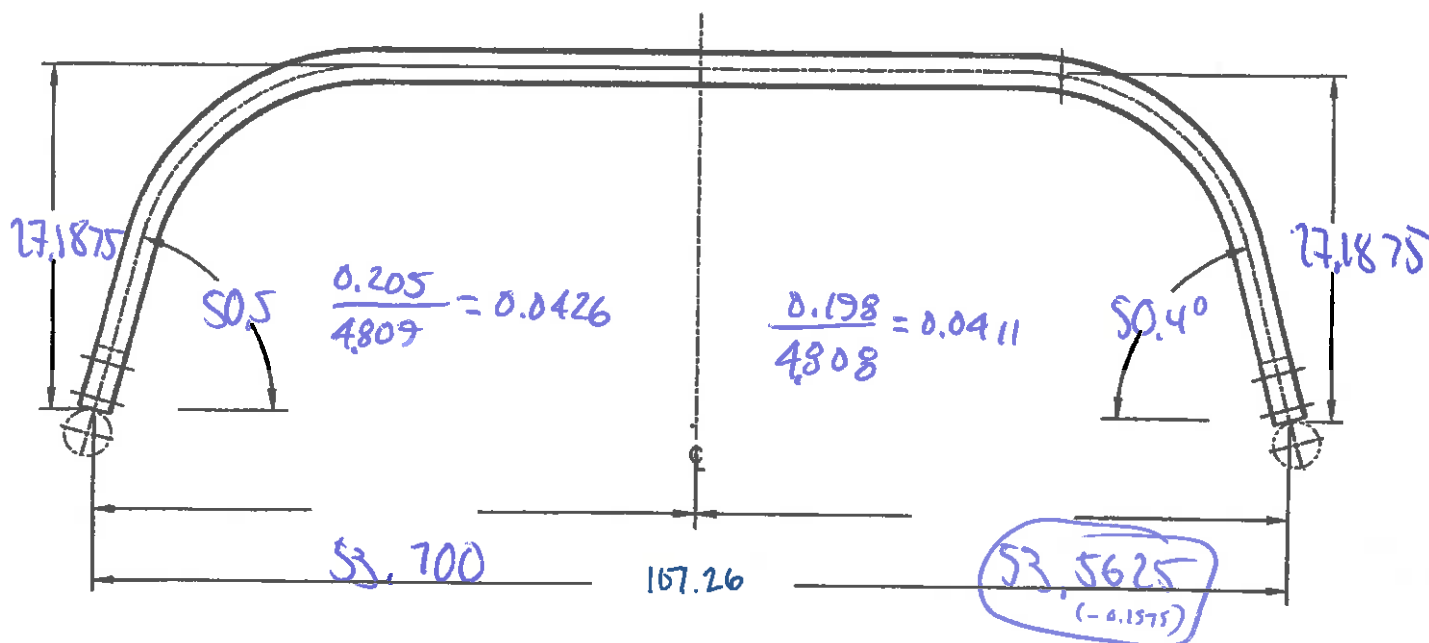
| Part / Item     | Component Name                         | Quantity      | Operation                          | Container |
|-----------------|----------------------------------------|---------------|------------------------------------|-----------|
| D212-664-101TRN | Crosstube Turning Detail               | 1 pcs (1 ea)  | 110-Packaging 1 - Pick Kit         | 5176888   |
| D2893-1         | Support                                | 2 pcs (2 ea)  | 220-Crosstubes - 4 - B4B           |           |
| D3595-063-450   | Rubber Cushion 0.63" Wide X 4.50" Long | 4 pcs (4 ea)  | 220-Crosstubes - 4 - B4B           |           |
| MS21920-25      | Clamp                                  | 4 Ea (4 ea)   | 220-Crosstubes - 4 - B4B           |           |
| AN6-35A         | Bolt                                   | 4 Ea (4 ea)   | 240-Packaging 1-1 - Pick Kit - B4B | 5054440   |
| AN6-35A         | Bolt                                   | 4 Ea (4 ea)   | 240-Packaging 1-1 - Pick Kit - B4B | 5184944   |
| D3428           | Placard                                | 1 pcs (1 ea)  | 240-Packaging 1-1 - Pick Kit - B4B | 5112844   |
| MS21042L5       | Nut                                    | 6 Ea (6 ea)   | 240-Packaging 1-1 - Pick Kit - B4B | 5182044   |
| NAS1149D0553J   | Washer                                 | 18 Ea (18 ea) | 240-Packaging 1-1 - Pick Kit - B4B | 5135144   |

| Job Allocations                    |                              |          |           |           |
|------------------------------------|------------------------------|----------|-----------|-----------|
| Operation                          | Component Part               | Required | Inventory | Allocated |
| 110-Packaging 1 - Pick Kit         | D212-664-101TRN              | 1        | 4         | 0         |
| 220-Crosstubes - 4 - B4B           | D2893-1 <i>S173692</i>       | ②        | 7         | 0         |
|                                    | D3595-063-450 <i>S177076</i> | ④        | 53        | 0         |
|                                    | MS21920-25 <i>S180180</i>    | ④        | 97        | 0         |
| 240-Packaging 1-1 - Pick Kit - B4B | AN6-35A                      | 4        | 59        | 0         |
|                                    | AN6-36A                      | 4        | 53        | 0         |
|                                    | D3428-1                      | 1        | 31        | 0         |
|                                    | MS21042L6                    | 6        | 300       | 0         |
|                                    | NAS1149D0663J                | 18       | 1,130     | 0         |
| Part Specifications                |                              |          |           |           |
| Specifications could not be found. |                              |          |           |           |

Plex 5/13/19 9:03 AM Dart.lajeunesse.marie

|                                               |        |              |              |
|-----------------------------------------------|--------|--------------|--------------|
| DART AEROSPACE LTD                            |        | Work Order:  | 194988       |
| Description: Crosstube High Fwd (205/212/412) |        | Part Number: | D212-664-101 |
| Inspection Dwg: D212-664-141                  | Rev: E | Page 1 of 1  |              |

| Required Dimension | Min    | Max   |
|--------------------|--------|-------|
| Height             | 26.67  | 27.17 |
| 1/2 Span           | 53.59  | 53.85 |
| Angle              | 49     | 52    |
| Total Span         | 107.18 | 107.7 |
| Bending Passes     | 3      | --    |
| Crushing           | --     | 7.2%  |



|                | Side A | Side B |
|----------------|--------|--------|
| Bending Passes | 4      | 4      |
| Crushing       | 4.3%   | 4.1%   |
| Comments       |        |        |
|                |        |        |
|                |        |        |
|                |        |        |
|                |        |        |

2.302  
2.507

2.305  
2.503

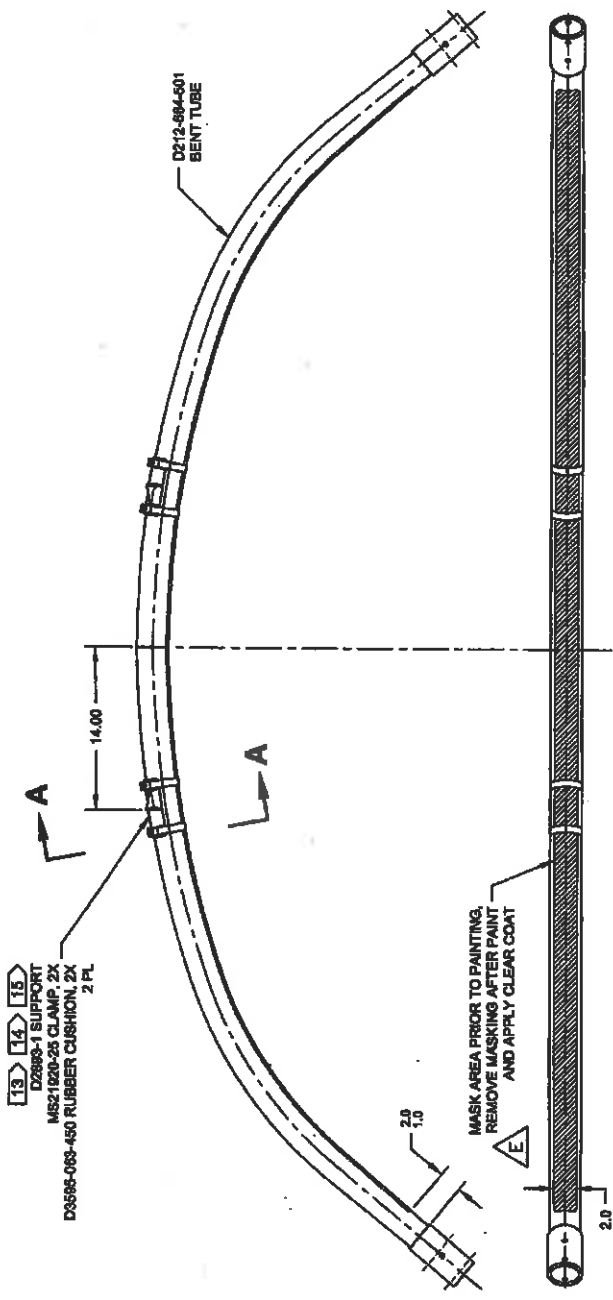
|                 |  |
|-----------------|--|
| QC15 Inspection |  |
| Date            |  |

| Rev | Date     | Change                             | Revised by | Approved |
|-----|----------|------------------------------------|------------|----------|
| A   | 07.02.06 | New Issue                          | KJ/JM      |          |
| B   | 08.04.21 | Dwg Rev updated                    | KJ/JM      |          |
| C   | 10.04.01 | Dwg Rev updated                    | KJ         |          |
| D   | 12.04.16 | Added bending, crushing dimensions | KJ         |          |
| E   | 14.07.28 | Revised max crushing %             | KJ         |          |
| F   | 16.01.15 | Revised Height min/max dimensions  | KJ         |          |

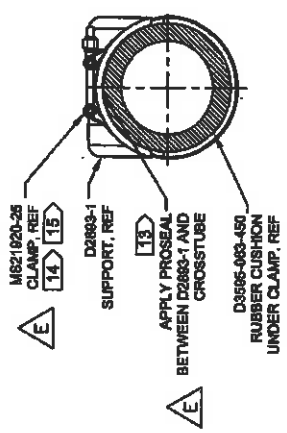




1 2 3 4 5 6 7 8



SYN  
D212-864-141/-141F  
ASSEMBLY DETAIL



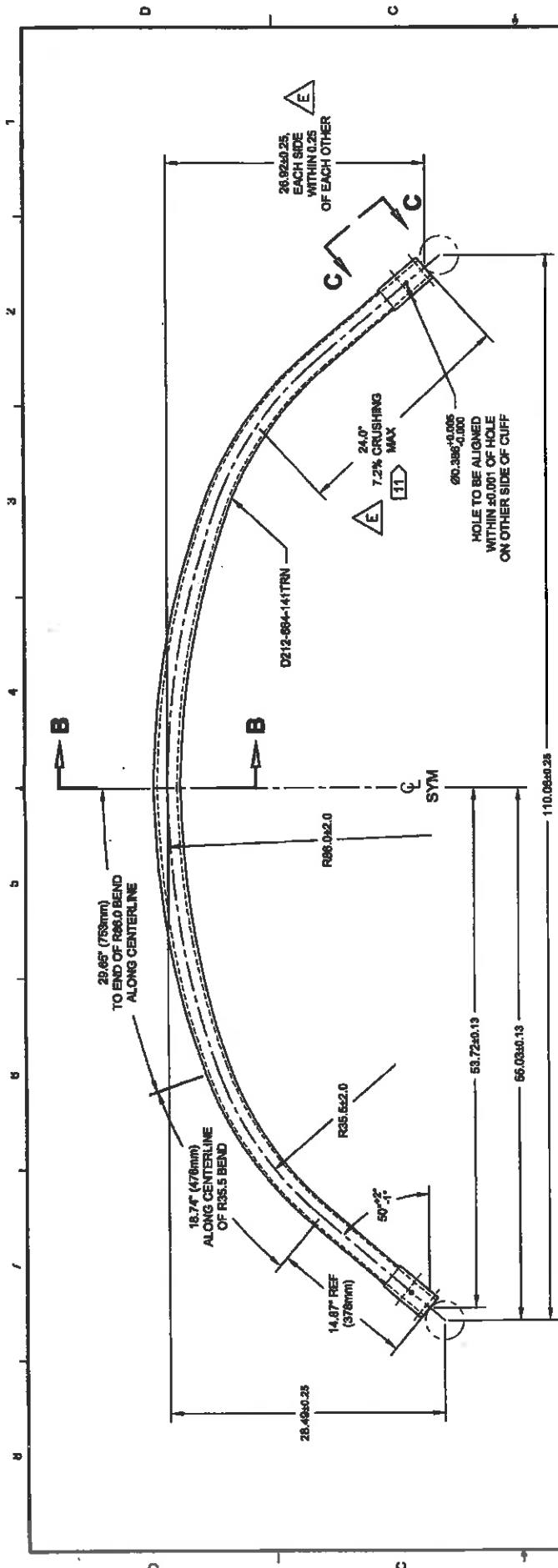
RELEASED  
R 2014-05-28  
JND

|            |          |                                                                                                                                                  |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | 0        | DART AEROSPACE LTD                                                                                                                               | REV. E       |
| DRAWN      | 0        | HARRISBURG, ONTARIO, CANADA                                                                                                                      |              |
| CHECKED    | 0        | DRAWING NO.                                                                                                                                      | SHEET 2 OF 5 |
| MFG. APPR. | 0        | D212-864-141                                                                                                                                     | SCALE        |
| APPROVED   | 0        | TITLE                                                                                                                                            | NTS          |
| DE APPR.   | 0        | XTUBE ASSY (205/212/412 HI FWD)                                                                                                                  |              |
| DATE       | 14.04.01 | CONFIDENTIAL & PROP. BY DART AEROSPACE LTD                                                                                                       |              |
|            |          | NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD |              |

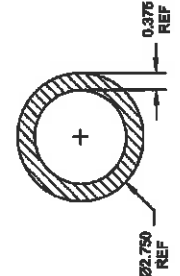


|            |          |                                 |              |
|------------|----------|---------------------------------|--------------|
| DESIGN     | 10       | <b>DART AEROSPACE LTD</b>       |              |
| DRAWN      | 42       | HAMMERSBURY, ONTARIO, CANADA    |              |
| CHECKED    | 42       | DRAWING NO.                     | REV. E       |
| MFG. APPR. | 42       | D212-684-141                    | SHEET 4 OF 5 |
| DE APPR.   | 42       | TITLE                           | SCALE        |
| DATE       | 14.04.01 | XTUBE ASS'Y (205/212412 HI FWD) | NTS          |

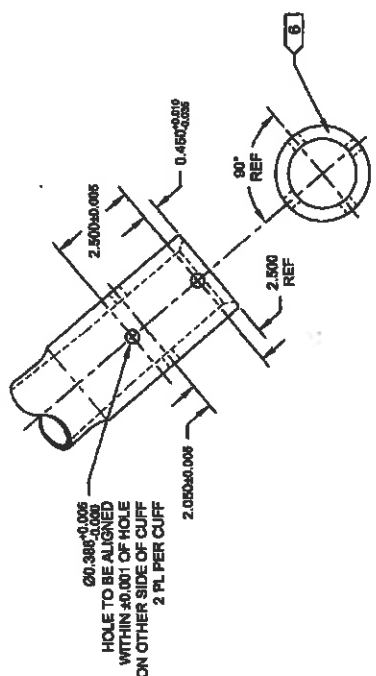
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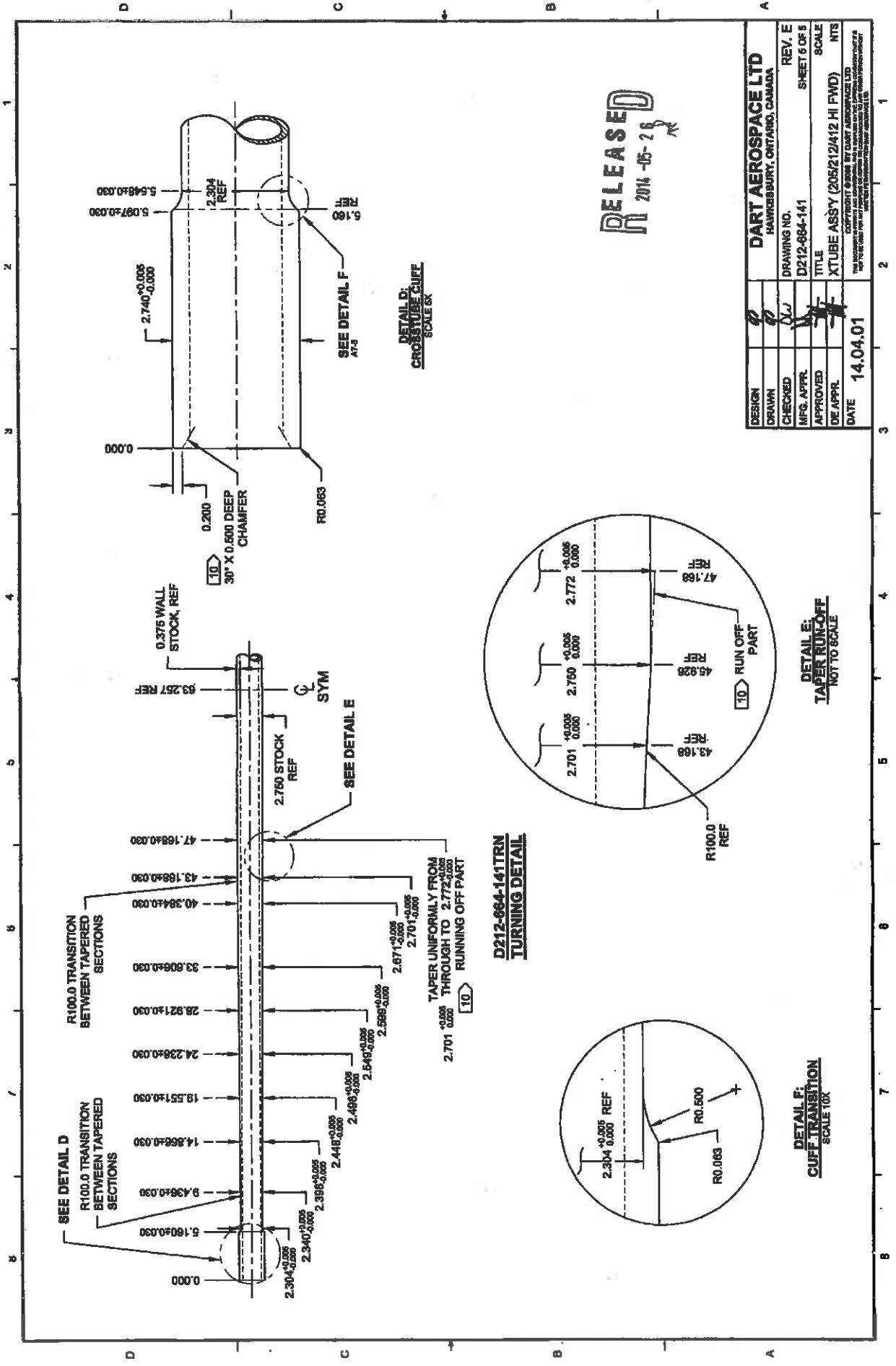
**D212-884-501**  
**BENDING AND DRILLING DETAIL**



**SECTION B-B**  
**SCALE 4X**



**VIEW C-C: CUFF DETAIL**  
**SCALE 3X**



ml 4 July 2019



Entered: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

NCR No. 19-7235

Job: 194988

Part No. D212-604-101

Route update only ☐

| DISPOSITION                                                                                                                                                                                                                                                                                                                                                                          |                   | DEPARTMENT/PROCESS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                            |                                                                                                                                      |                                                                                                                                                     |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------|
| Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input checked="" type="checkbox"/>                                                                                                                                                                                                                                                                   |                   | Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Cross tube <input checked="" type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/> | Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/> | Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |
| Date: <u>19/5/16</u>                                                                                                                                                                                                                                                                                                                                                                 | Sequence #: _____ | QTY Affected: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                            |                                                                                                                                      |                                                                                                                                                     |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                     |                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                            |                                                                                                                                      |                                                                                                                                                     |
| <p>One side is bent narrow (nominal nominal).<br/>bent narrow below<br/>below</p>                                                                                                                                                                                                                                                                                                    |                   | <p>Acceptable. Overall span is in tolerance.<br/>Overall span is in</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                                                                                                            |                                                                                                                                      |                                                                                                                                                     |
| Root Cause                                                                                                                                                                                                                                                                                                                                                                           |                   | Completed By <u>INS 12 4/19/16</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                            |                                                                                                                                      |                                                                                                                                                     |
| Operator <input checked="" type="checkbox"/><br>Manufacturing Process <input checked="" type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |                   | Lead hand / Supervisor <u>Dean Lee M.</u><br><u>P. B. D.</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                            |                                                                                                                                      |                                                                                                                                                     |
|                                                                                                                                                                                                                                                                                                                                                                                      |                   | QC / QA Coordinator <u>DAS 68 9-89</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                            |                                                                                                                                      |                                                                                                                                                     |
| Fault Category                                                                                                                                                                                                                                                                                                                                                                       |                   | Fault Category                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                            |                                                                                                                                      |                                                                                                                                                     |
| Pressure/Forced <input checked="" type="checkbox"/><br>Bending <input checked="" type="checkbox"/><br>Crushing <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Other/Details: _____                                         |                   | Contamination <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Incomplete/Unclear Instructions <input type="checkbox"/><br>Drill Holes <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain Direction <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set/Set-up <input type="checkbox"/><br>Positioned Wrong <input type="checkbox"/><br>Outside Tolerance <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Misread <input type="checkbox"/> |                                                                                                                            |                                                                                                                                      |                                                                                                                                                     |



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## POHB043592



**Supplier:** SKY002-VC  
Skyservice  
6120 Midfield Road  
Mississauga  
ON  
L5P 1B1 Canada  
Phone: 905-678-5636  
Fax: 905-678-5841

**Attention:** Jenne, Heather

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**PO No:** POHB043592

**PO Date:** 5/30/19

**Due Date:** 5/30/19

**Purchase Order**

**Revision:**

**Revision Date:**

**Ship-To Contact:** Phone:

**Via:** Ground

**Pymt Terms:** Net 30

**Freight Terms:**

**Special Comments:**

### Items

| Line Item         | Job | Part         | Description                                                                                                                                                                                                                                                                                                                                            | Status | Account | Due Date | Order Quantity | Received Quantity | Balance  | Unit Price (CAD) | Extended Price  |
|-------------------|-----|--------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|----------|------------------|-----------------|
| ① 194991          |     | D212-664-101 | Fwd Crosstube - High<br>: TC STC SH01-9 Issue 3, FAA<br>STC SR01298NY 09/01/08, EASA<br>STC EASA.IM.R.S.01304 07/03/06,<br>DGAC MEXICO STC IA-316/2015<br>15/06/17<br>*** WEAR LATEX GLOVES WHEN<br>HANDLING CROSSTUBE*** Liquid<br>Penetrant Inspection as per QSI<br>038 LPI as per ASTM 1417 Level 2<br>Attach copy of NDT results to work<br>order | Firmed | -       | 5/30/19  | 1 pcs          | 0 pcs             | 1 pcs    | \$115.00/pcs     | \$115.00        |
|                   |     |              | 1 X JUN 03 2019                                                                                                                                                                                                                                                                                                                                        | Firmed | -       | 5/30/19  | 1 pcs          | 0 pcs             | 1 pcs    | \$115.00/pcs     | \$115.00        |
|                   |     |              | 1 X JUN 03 2019                                                                                                                                                                                                                                                                                                                                        | Firmed | -       | 5/30/19  | 1 pcs          | 0 pcs             | 1 pcs    | \$115.00/pcs     | \$115.00        |
|                   |     |              | 1 X JUN 03 2019                                                                                                                                                                                                                                                                                                                                        | Firmed | -       | 5/30/19  | 1 pcs          | 0 pcs             | 1 pcs    | \$115.00/pcs     | \$115.00        |
| <b>Sub Total:</b> |     |              |                                                                                                                                                                                                                                                                                                                                                        |        |         |          | <b>4</b>       | <b>0</b>          | <b>4</b> |                  | <b>\$460.00</b> |

DAS  
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9-89

|                   |  |              |                                                                                                                                                                                                                            |        |   |         |          |          |          |              |                 |
|-------------------|--|--------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---|---------|----------|----------|----------|--------------|-----------------|
| ② 191000          |  | D350-748-103 | AS350 / AS355 Stainless Steel<br>Fwd Crosstube<br>: TC STC SH06-27 Issue 2, FAA<br>STC SR02359NY 11/03/04, EASA<br>STC EASA.10016903 Revision 2<br>10/09/03, BRAZIL 2009S04-04<br>09/04/06<br>ISSUE P/O TO SKY<br>SERVICE: | Firmed | - | 5/30/19 | 1 pcs    | 0 pcs    | 1 pcs    | \$115.00/pcs | \$115.00        |
|                   |  |              | 1 X JUN 03 2019                                                                                                                                                                                                            | Firmed | - | 5/30/19 | 1 pcs    | 0 pcs    | 1 pcs    | \$115.00/pcs | \$115.00        |
|                   |  |              | 1 X JUN 03 2019                                                                                                                                                                                                            | Firmed | - | 5/30/19 | 1 pcs    | 0 pcs    | 1 pcs    | \$115.00/pcs | \$115.00        |
|                   |  |              | 1 X JUN 03 2019                                                                                                                                                                                                            | Firmed | - | 5/30/19 | 1 pcs    | 0 pcs    | 1 pcs    | \$115.00/pcs | \$115.00        |
| <b>Sub Total:</b> |  |              |                                                                                                                                                                                                                            |        |   |         | <b>4</b> | <b>0</b> | <b>4</b> |              | <b>\$460.00</b> |



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## POHB043592



### Items

| Line Item  | Job    | Part         | Description                                                                                                                                                                                              | Status | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
|------------|--------|--------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|---------|------------------|----------------|
| 3          | 193226 | D350-748-203 | AS350 / AS355 Stainless Steel Aft Crosstube<br>: TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06<br>ISSUE P/O TO SKY SERVICE: | Firmed | -       | 5/30/19  | 1 pcs          | 0 pcs             | 1 pcs   | \$115.00/pcs     | \$115.00       |
|            | 191001 |              | 1 X JUN 0 3 2019                                                                                                                                                                                         | Firmed | -       | 5/30/19  | 1 pcs          | 0 pcs             | 1 pcs   | \$115.00/pcs     | \$115.00       |
|            | 191002 |              | 1 X JUN 0 3 2019                                                                                                                                                                                         | Firmed | -       | 5/30/19  | 1 pcs          | 0 pcs             | 1 pcs   | \$115.00/pcs     | \$115.00       |
| Sub Total: |        |              |                                                                                                                                                                                                          |        |         |          | 3              | 0                 | 3       |                  | \$345.00       |

Grand Total: \$1,265.00

### Order Notes

Procurement Quality Clauses  
A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)

A022 Apical Processing  
A024 process certifications  
A026 certification of material conformance

A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

*Handwritten signature and date: 03-06-19*

Plex 6/3/19 8:15 AM Dart.Guerin.Kimberley



**skyservice****Work Order Traveler**  
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Québec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 365

|                          |                               |               |                         |
|--------------------------|-------------------------------|---------------|-------------------------|
| WO #: MWO40600           | Customer: Dart Aerospace Ltd. | Dept: NDT YUL | Reference: POR3043592 ✓ |
| Descr:                   | PN:                           | S/N:          | Qty: 1                  |
| Make:                    | Model:                        | Reg:          | A/C S/N:                |
| TSN:                     | CSN:                          | TSO:          |                         |
| Task: <b>UNSCHEDULED</b> |                               |               | Sequence: 1             |

**Work Required:****CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 11 CROSSTUBES**

ITEM ID: D350-748-203 AS350/AS355 STAINLESS STEEL AFT CROSSTUBE

1 - WORK ORDER ID#: 191002 ✓

2 - WORK ORDER ID#: 191001 ✓

3 - WORK ORDER ID#: 193226 ✓

ITEM ID: D350-748-103 AS350/AS355 STAINLESS STEEL FWD CROSSTUBE

4 - WORK ORDER ID#: 190999 ✓

5 - WORK ORDER ID#: 191081 ✓

6 - WORK ORDER ID#: 191000 ✓

7 - WORK ORDER ID#: 191080 ✓

ITEM ID: D212-604-101 FWD CROSSTUBE - HGH

8 - WORK ORDER ID#: 194991 ✓

9 - WORK ORDER ID#: 194990 ✓

10 - WORK ORDER ID#: 194989 ✓

11 - WORK ORDER ID#: 194988 ✓

DAS  
68  
9-89**RECEIVED**

JUN 03 2019

DART AEROSPACE LTD.

|                                                                                                |                     |              |                                                                                       |                |               |
|------------------------------------------------------------------------------------------------|---------------------|--------------|---------------------------------------------------------------------------------------|----------------|---------------|
| <b>Action Taken:</b>                                                                           |                     | <b>Date:</b> | <b>Initial/Stamp:</b>                                                                 |                |               |
| LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-11) AS PER ASTM1417M-16 |                     | 30 MAY 2019  |  |                |               |
| NO CRACK FOUND                                                                                 |                     |              |                                                                                       |                |               |
| PEN ZL-37, MPO23206, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO23451, UV LIGHT M-20142    |                     |              |                                                                                       |                |               |
| <b>Description</b>                                                                             | <b>Location P/N</b> | <b>Qty</b>   | <b>Batch</b>                                                                          | <b>S/N Off</b> | <b>S/N On</b> |
| - N/A -                                                                                        |                     |              |                                                                                       |                |               |
|                                                                                                |                     |              |                                                                                       |                |               |
|                                                                                                |                     |              |                                                                                       |                |               |
|                                                                                                |                     |              |                                                                                       |                |               |
|                                                                                                |                     |              |                                                                                       |                |               |
|                                                                                                |                     |              |                                                                                       |                |               |

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

|                   |                                                                                     |                                                                                                               |              |
|-------------------|-------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------|--------------|
| <b>Signature:</b> |  | <b>ACA/SCA Stamp</b><br> | <b>Date:</b> |
| <b>Name:</b>      |                                                                                     |                                                                                                               |              |

ANTONINO MARCHETTA

## 5.0 PARTS LIST

## 5.1 HIGH GEAR CROSSTUBES

| Item | QTY<br>-101 | QTY<br>-201 | QTY<br>-203 | Part Number     | Description                                                                                            |
|------|-------------|-------------|-------------|-----------------|--------------------------------------------------------------------------------------------------------|
|      | X           |             |             | D212-664-101    | CROSSTUBE INSTALLATION,<br>204/205/210/212/214/412, UH-1H,<br>UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD |
|      |             | X           |             | D212-664-201    | CROSSTUBE INSTALLATION,<br>204/205/210/212/214, UH-1H,<br>UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT     |
|      |             |             | X           | D412-664-203    | CROSSTUBE INSTALLATION,<br>412 HIGH AFT                                                                |
| 1    | 1           |             |             | D212-664-141    | CROSSTUBE ASSEMBLY,<br>204/205/210/212/214/412, UH-1H,<br>UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD     |
| 2    |             | 1           |             | D212-664-241    | CROSSTUBE ASSEMBLY,<br>204/205/210/212/214, UH-1H,<br>UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT         |
| 3    |             |             | 1           | D412-664-243    | CROSSTUBE ASSEMBLY,<br>412 HIGH AFT                                                                    |
| 10   | 2           |             |             | * D2893-1       | SUPPORT                                                                                                |
| 11   | 4           |             |             | * D3595-063-450 | RUBBER CUSHION                                                                                         |
| 12   | 4           |             |             | * MS21920-25    | CLAMP (OR MS21920-26)                                                                                  |
| 13   | 4           |             |             | AN6-35A         | BOLT                                                                                                   |
| 14   | 4           |             |             | AN6-36A         | BOLT                                                                                                   |
| 15   | 6           |             |             | MS21042L6       | NUT (OR MS21042-6)                                                                                     |
| 16   | 18          |             |             | AN960JD616      | WASHER                                                                                                 |
| 20   |             | 2           |             | * D2940-1       | SUPPORT                                                                                                |
| 21   |             | 4           |             | * D3595-063-530 | RUBBER CUSHION                                                                                         |
| 22   |             | 4           |             | * MS21920-28    | CLAMP (OR MS21920-30)                                                                                  |
| 23   |             | 4           |             | AN6-40A         | BOLT                                                                                                   |
| 24   |             | 2           |             | AN6-41A         | BOLT                                                                                                   |
| 25   |             | 6           |             | MS21042L6       | NUT (OR MS21042-6)                                                                                     |
| 26   |             | 18          |             | AN960JD616      | WASHER                                                                                                 |
| 30   |             |             | 1           | * D2896-1       | SUPPORT                                                                                                |
| 32   |             |             | 2           | * D3595-063-570 | RUBBER CUSHION                                                                                         |
| 33   |             |             | 4           | * MS21920-28    | CLAMP                                                                                                  |
| 34   |             |             | 2           | * MS21920-30    | CLAMP (OR MS21920-32)                                                                                  |
| 35   |             |             | 4           | AN6-40A         | BOLT                                                                                                   |
| 36   |             |             | 2           | AN6-41A         | BOLT                                                                                                   |
| 37   |             |             | 6           | MS21042L6       | NUT (OR MS21042-6)                                                                                     |
| 38   |             |             | 18          | AN960JD616      | WASHER                                                                                                 |
| 39   |             |             | 2           | * D3189-1       | CHAFING SHIELD                                                                                         |
| 50   | 1           | 1           |             | D3428-1         | PLACARD                                                                                                |

\* REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-141/241 OR D412-664-243 ASSEMBLIES ABOVE.

NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AAI SKIDTUBES.

## PAGE 1 OF 1

**Description:** CROSSTUBE INSTALLATION, HIGH FWD

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